

Work Order ID 131278

Wednesday, April 01, 2015 3:33:37 PM

131278

Page 1

Item ID: D4273-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly, LH
Start Date: 4/01/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/10/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: *M* Date: 15-4-1 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4273	E								
D4279	B								

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00***100***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION E-
E ON PAGE 2 DWG D4273, NEED TO WELDED AFTHET MESH IS
INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 base mesh (MADE ON THIS W/O) and tack weld all mesh on
basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear
fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

1x CC 15-4-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110							DAS 43		
QC	Memo	0.00					9-89		APR 09 2015
Quality Control									
120	QC6- Inspect dimensions to drawing	0.00							
120							DAS 43		
QC	Memo	0.00					9-89		APR 09 2015
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1 ϕ 15-49 DAS 34 88

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat m 131545 1ST COAT: START TIME: 1:20 OVEN TEMPERATURE: 400° FINISH TIME: 1:50. ***** 2nd coat if necessary***** 2ND COAT: START TIME: 3:15 OVEN TEMPERATURE: 400° FINISH TIME: 3:45.								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 of 15-4-9 DAS 34 9-89

1 of 15-4-9 DAS 34 9-89

1 of 20 15/04/10 DAS 15 9-89

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>W/O</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 1504-10
CMF
15-4-10

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 131278

131278

Parent Item: D4273-041

D4273-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 4/01/15

Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC IPP Rev:B
11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03
AS PER DWG REV.D DD verf:EC IPP REV:D 12.07.24 AS PER DWG
REV.E DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4672-1		Manufactured	No			100	Each	39.0000	2	2			

D4672-1

Blanking Plate

**

CC 15-4-9

Location	Loc Qty	Loc Code
WA004	39	
121464	4	
125138	7	
127389	6	
128829	22	

(2x)

M304EX0.75-16F

Purchased

No

100

sf

1,048.861

32

34

M304FX0 75-16F

Expanded Metal Flat SS

**

CC 15-4-9

Location	Loc Qty	Loc Code
WA004	480	
M131848	480	
WA006	568.8612	
M131107	129.8612	
M131629	439	

(3x)

D3913-1

Manufactured

No

100

Each

4.0000

1

1

D3913-1

Rib

**

CC 15-4-9

Location	Loc Qty	Loc Code
WA004	4	
117110	4	

(1x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

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Work Order ID: 131278

131278

Parent Item: D4273-041

D4273-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 4/01/15

Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each 2.0000 1 1

D3913-3

Rib

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

2

125309

2

D3913-9 Manufactured No

100 Each 2.0000 1 1

D3913-9

Hinge Rib

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

2

125111

2

D3916-5 Manufactured No

100 Each 16.0000 3 3

D3916-5

Light Rib

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

16

120391

4

120393

7

121578

5

D4017-7 Manufactured No

100 Each 23.0000 1 1

D4017-7

Rib

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

23

116025

23

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

D4034-041	Manufactured	No	100	Each	3.0000	1	1	
D4034-041								**
Aft Upper Rib Assembly								<u>CC 15-4-9</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA004	3				
			<u>128381</u>	3				
D4277-3	Manufactured	No		100	Each	1.0000	1	1
D4277-3								**
Rib								<u>CC 15-4-9</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA004	1				
			<u>124687</u>	1				
D4277-5	Manufactured	No		100	Each	6.0000	2	2
D4277-5								**
Rib								<u>CC 15-4-9</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA004	6				
			<u>102909</u>	6				
D4277-9	Manufactured	No		100	Each	3.0000	1	1
D4277-9								**
Rib								<u>CC 15-4-9</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA004	3				
			<u>118940</u>	3				
D4277-19	Manufactured	No		100	Each	3.0000	1	1
D4277-19								**
Rib								<u>CC 15-4-9</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA004	3				
			<u>119632</u>	3				

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Shop Packet Print

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Picklist Print

Wednesday, April 01, 2015 3:33:44 PM

Page 4

Work Order ID: 131278

Parent Item: D4273-041

Parent Item Name: Basket Base Assembly, LH

131278

D4273-041

Start Date: 4/01/15

Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

D4278-045 Manufactured No

D4278-045

Rib Assembly, Fwd Cham

D4278-047 Manufactured No

D4278-047

Upper Rib Assembly-Straight

100 Each 0.0000
B127567 → (2)

2 2

**

CC 15-4-9

100 Each 3.0000

1 1

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

3

116776

3

D4306-1 Manufactured No

D4306-1

Rib

100 Each 4.0000

1 1

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

4

122307

4

D4306-043 Manufactured No

D4306-043

Rib Assembly, LH

100 Each 1.0000

1 1

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

1

72324

1

D4306-045 Manufactured No

D4306-045

Rib Assembly

100 Each 0.0000

1 1

**

B125243 → (1)

CC 15-4-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Wednesday, April 01, 2015 3:33:44 PM

Page 5

Work Order ID: 131278

131278

Parent Item: D4273-041

D4273-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 4/01/15

Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

83.0000

2

2

D2581

Mounting Bracket

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

83

102265

38

127716

45

D3913-15

Manufactured No

100

Each

7.0000

1

D3913-15

Wide Handle Plate

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

7

117028

1

128895

4

129891

2

D4016-1

Manufactured No

100

Each

36.0000

3

3

D4016-1

Hinge Half, Base

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

36

120115

8

121919

7

129669

21

D4021-1

Manufactured No

100

Each

25.0000

3

3

D4021-1

Handle Plate

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

25

120273

1

129822

24

Wednesday, April 01, 2015 3:33:44 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Wednesday, April 01, 2015 3:33:44 PM

Page 6

Work Order ID: 131278

131278

Parent Item: D4273-041

D4273-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 4/01/15

Required Date: 4/10/15

Start Qty: 1.00

Required Qty: 1.00

D4279-5

Manufactured No

100

Each

6.0000

1

1

D4279-5

End Mesh, Basket

CC 15-4-9

Location

Loc Qty

Loc Code

WA006

6

103775

1

127368

5

D4279-7

Manufactured No

100

Each

13.0000

2

D4279-7

End Mesh, Basket

CC 15-4-9

Location

Loc Qty

Loc Code

WA006

13

103480

4

103734

6

125147

2

127810

1

D4279-9

Manufactured No

100

Each

6.0000

1

1

D4279-9

End Mesh, Basket

CC 15-4-9

Location

Loc Qty

Loc Code

WA006

6

105891

1

127741

5

DQA: _____ Date: _____



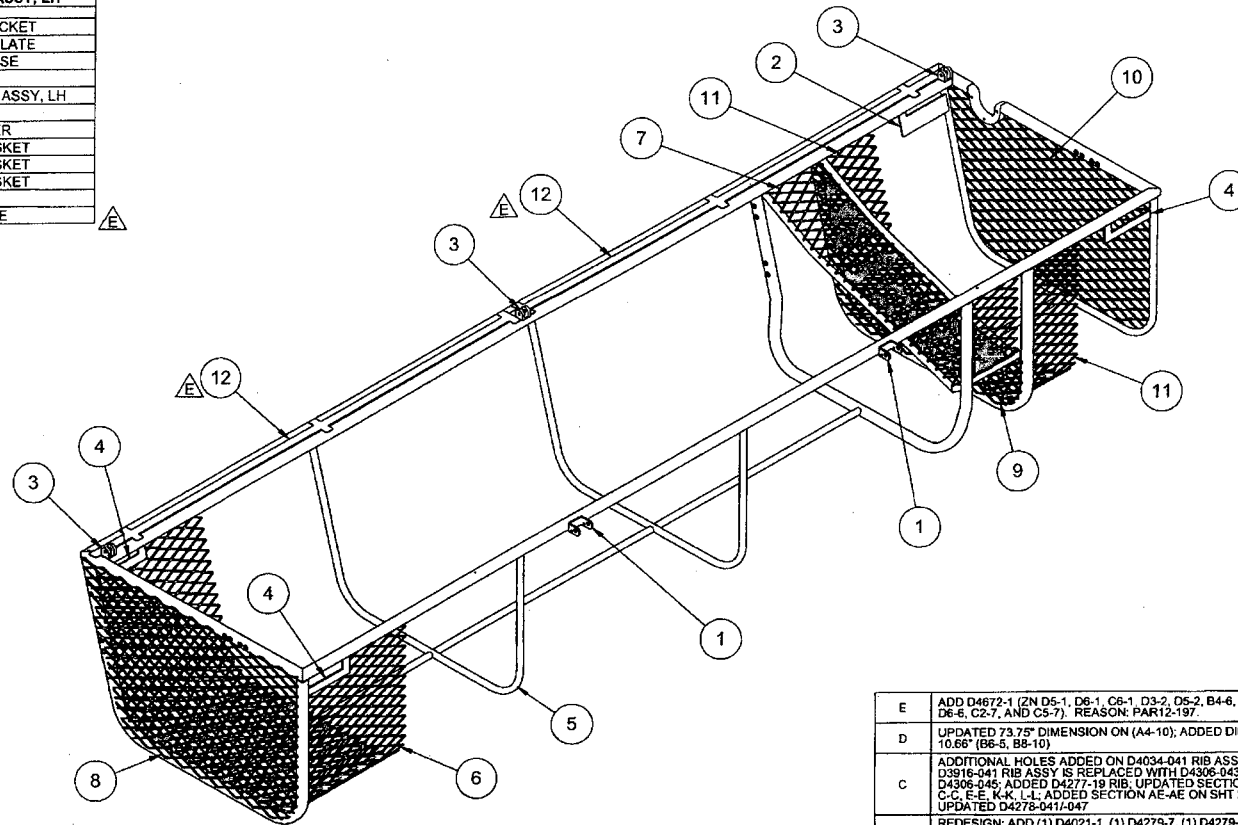
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

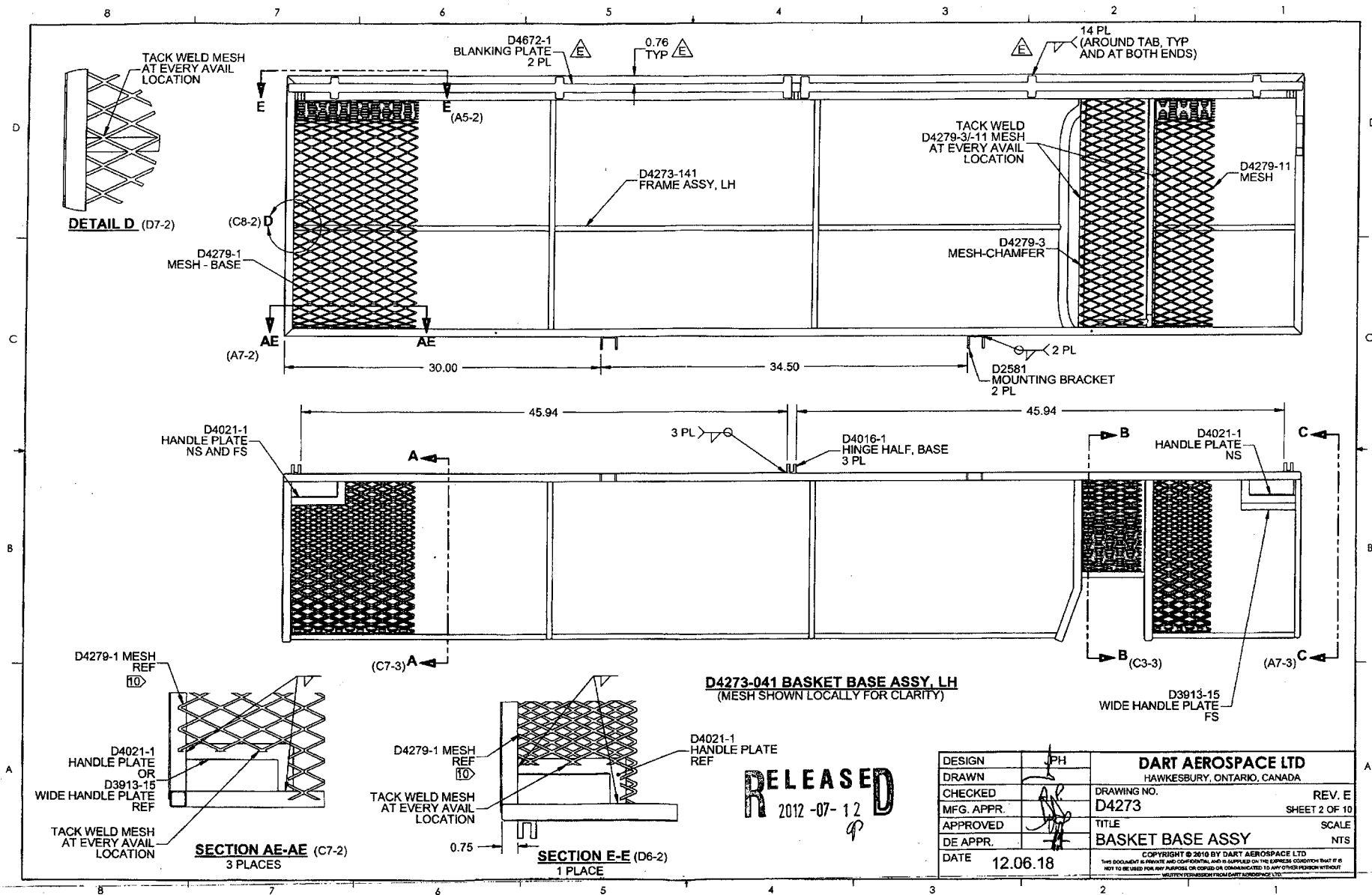
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

15-4-1
131278

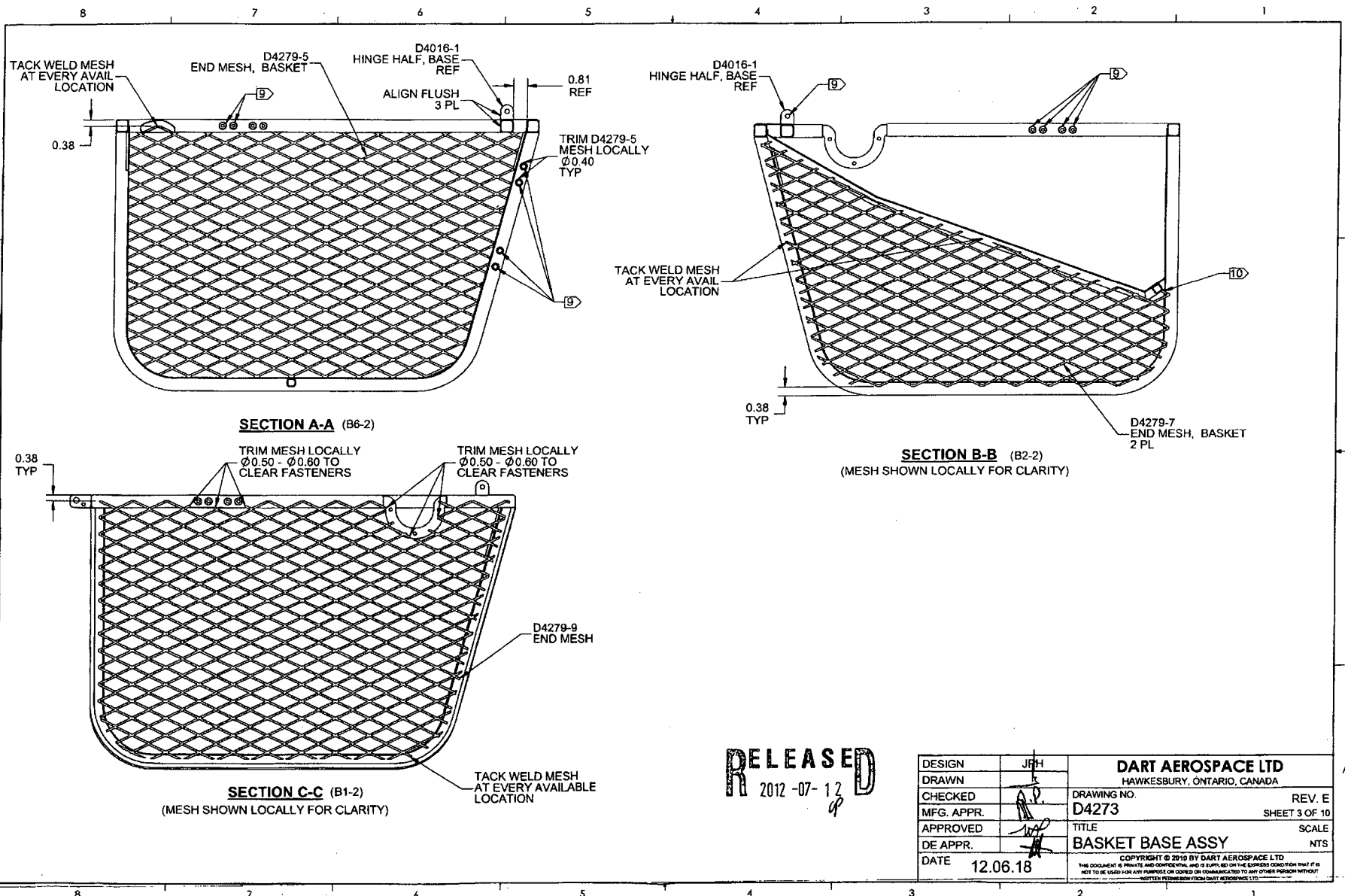
RELEASED
2012-07-12
PECN 12-61

E	ADD D4672-1 (2N D5-1, D6-1, C6-1, D3-2, D5-2, B4-6, C3-6, D6-6, C2-7, AND C5-7). REASON: PAR12-197.	MB	12.06.18
D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY. D3916-041 RIB ASSY IS REPLACED WITH D4306-043-044 & D4306-045. ADDED D4277-19 RIB. UPDATED SECTION B-B, C-C, E-E, K-K, L-L. ADDED SECTION AE-AE ON SHT 2. UPDATED D4278-041/-047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-8), RMV D4277-17, D4278-043 (SHT 4.8); ADD (1) D3916-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. E
MFG. APPR.	JPH	D4273	SHEET 1 OF 10
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	BASKET BASE ASSY	NTS
DATE	12.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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2012-07-12

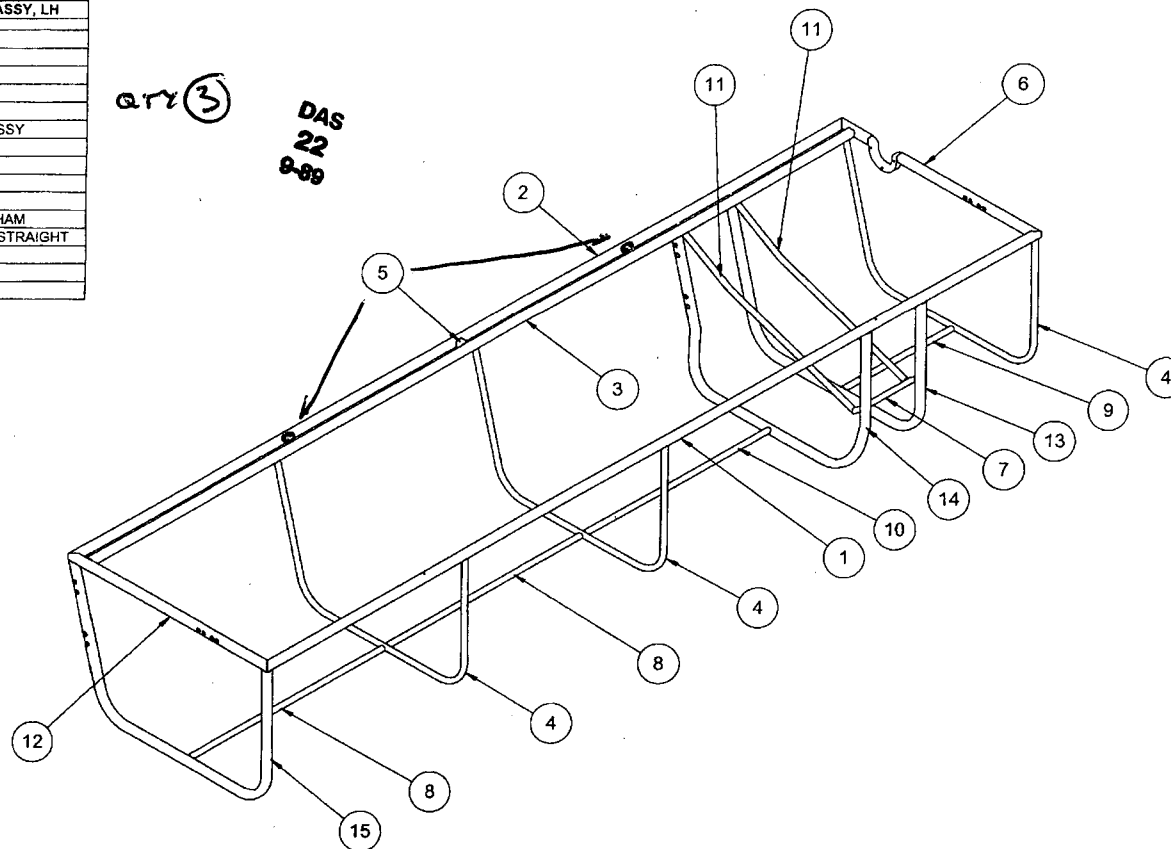
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4273	REV. E
MFG. APPR.			SHEET 2 OF 10
APPROVED		TITLE BASKET BASE ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2012-07-12

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4273	REV. E
MFG. APPR.			SHEET 3 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	12.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	X	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY



D4273-141 BASKET FRAME ASSY, LH

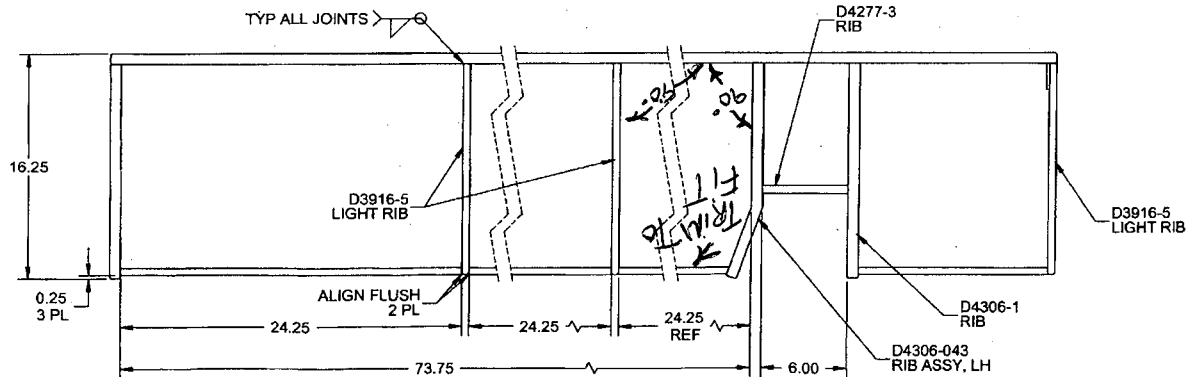
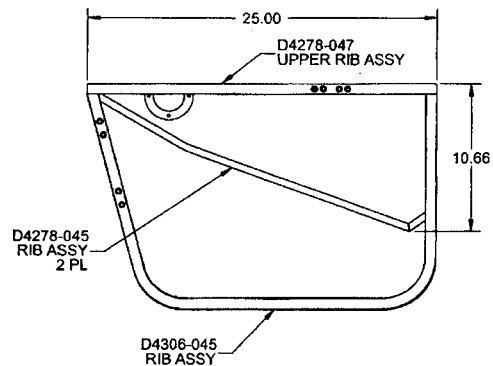
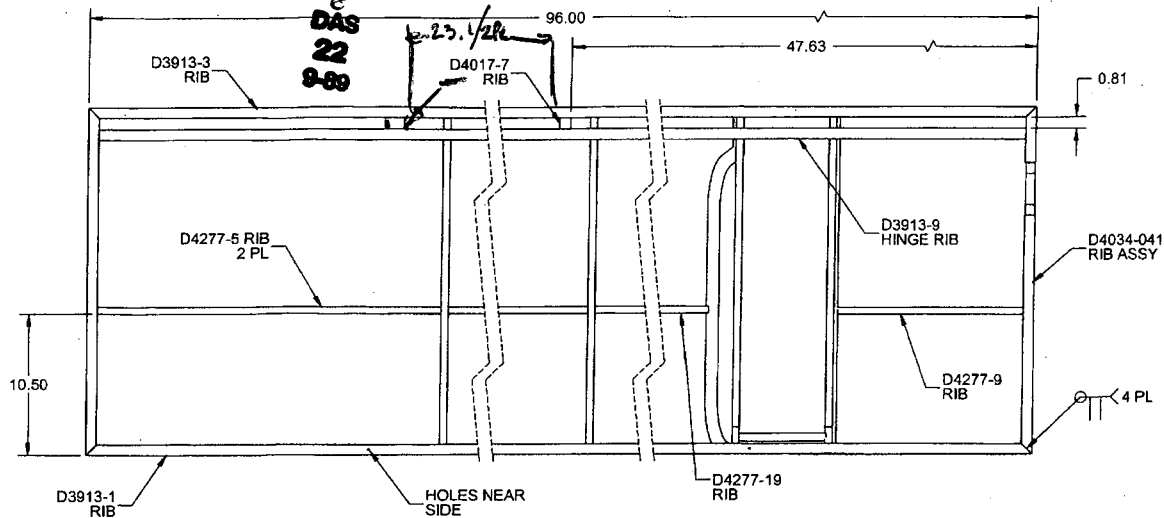
RELEASED
2012-07-12
UP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D4273	REV. E
MFG. APPR.		SHEET 4 OF 10	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	12.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

15.04.02

DAS
22
8.89



D4273-141 BASKET FRAME ASSY, LH

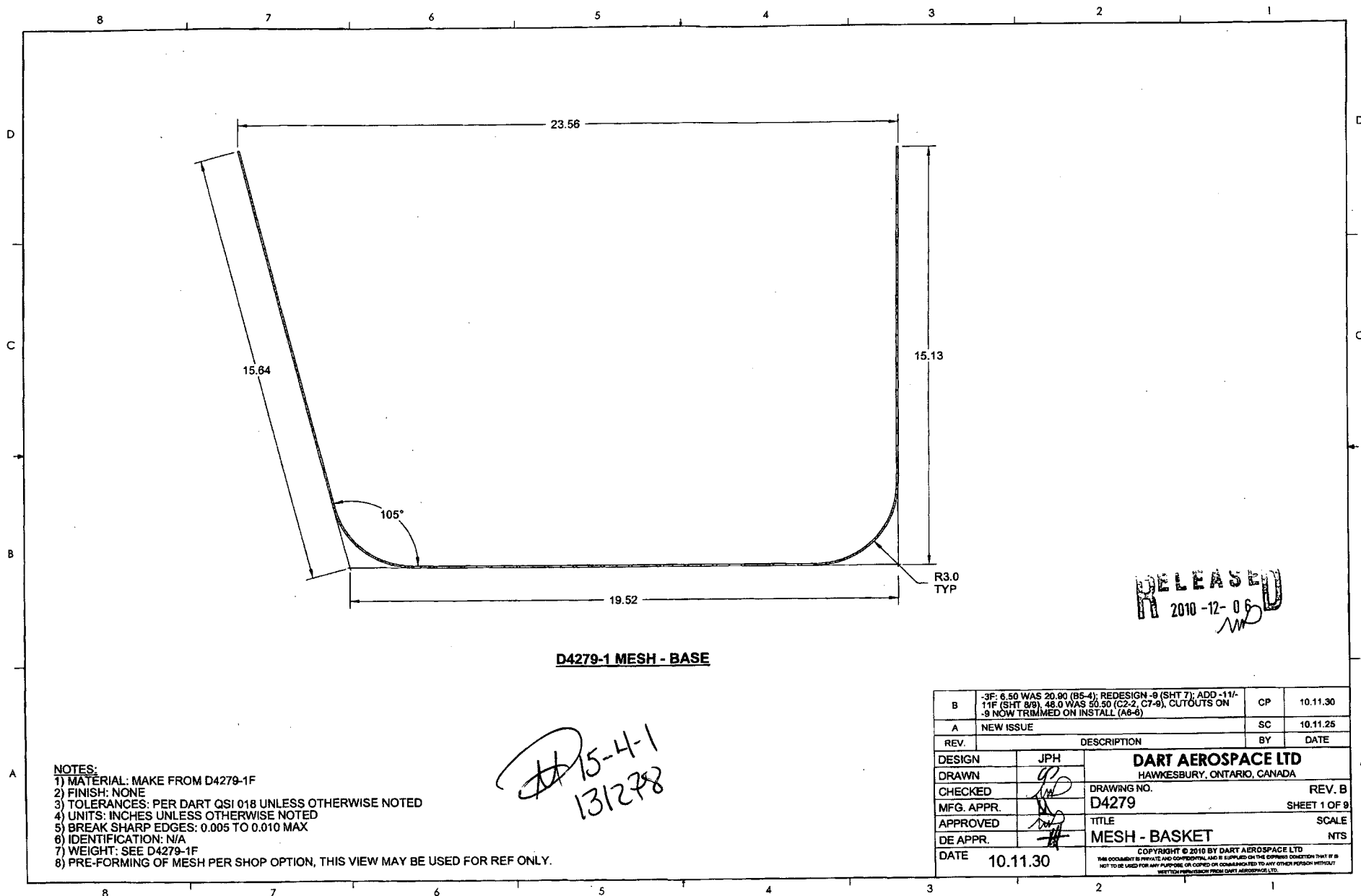
RELEASED
2012-07-12
UP

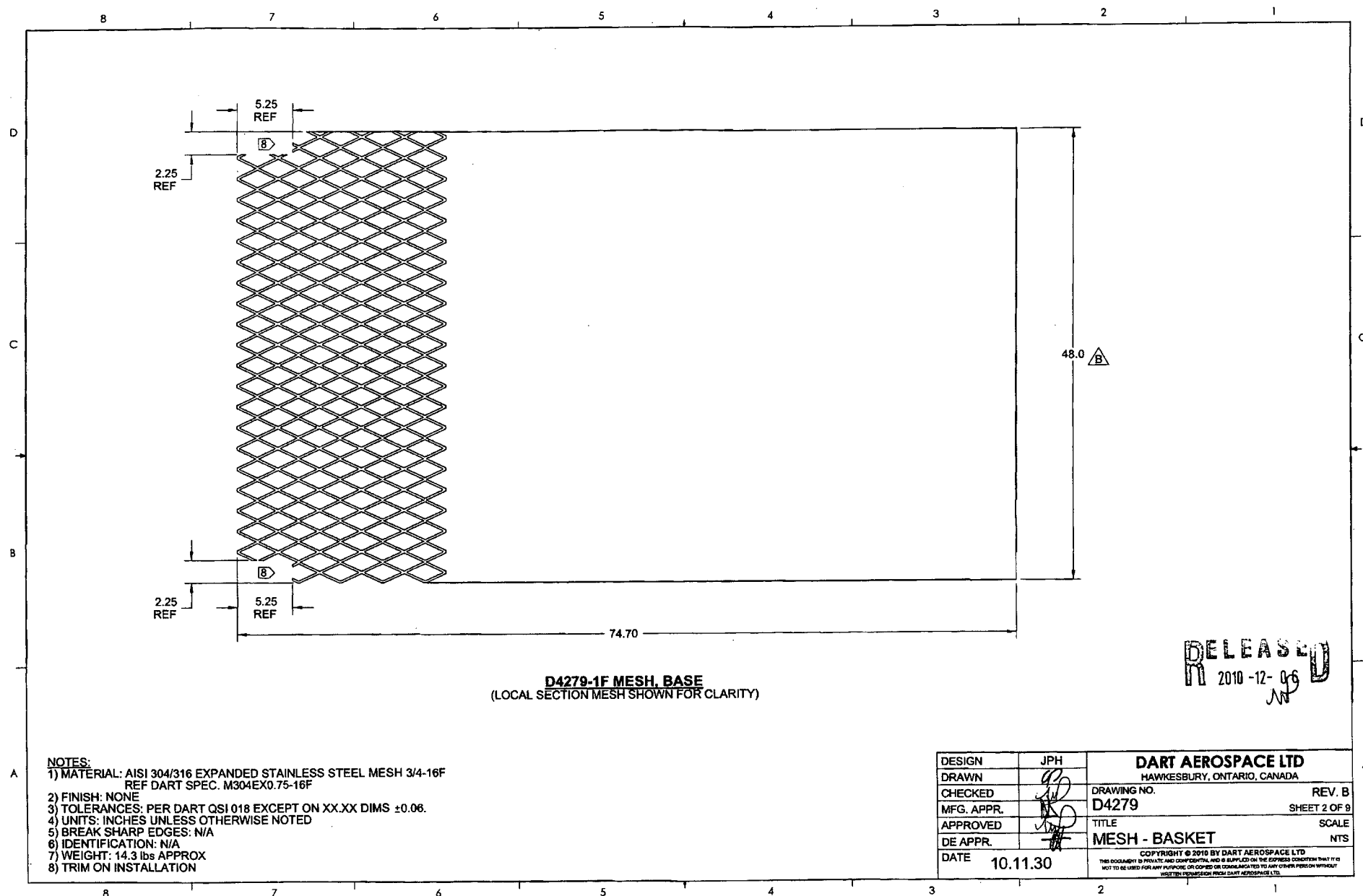
NOTES:

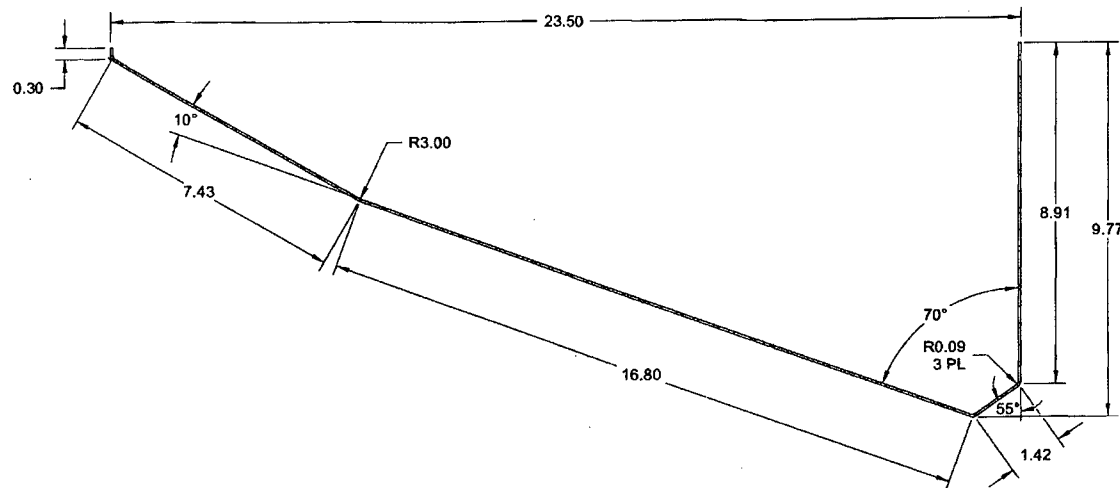
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.75 lbs
- 8) WELD PER DART QSI 004

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4273	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	12.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1







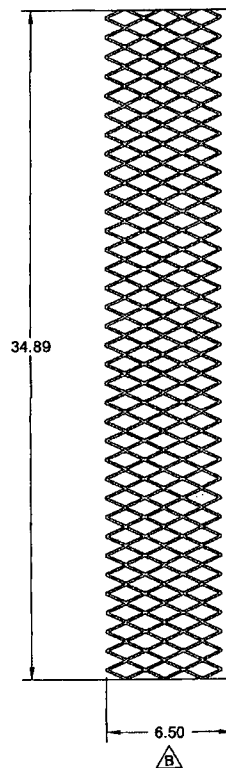
D4279-3 MESH-CHAMFER

RELEASED
2010-12-06
JPH

NOTES:

- 1) MATERIAL: MAKE FROM D4279-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-3F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 3 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



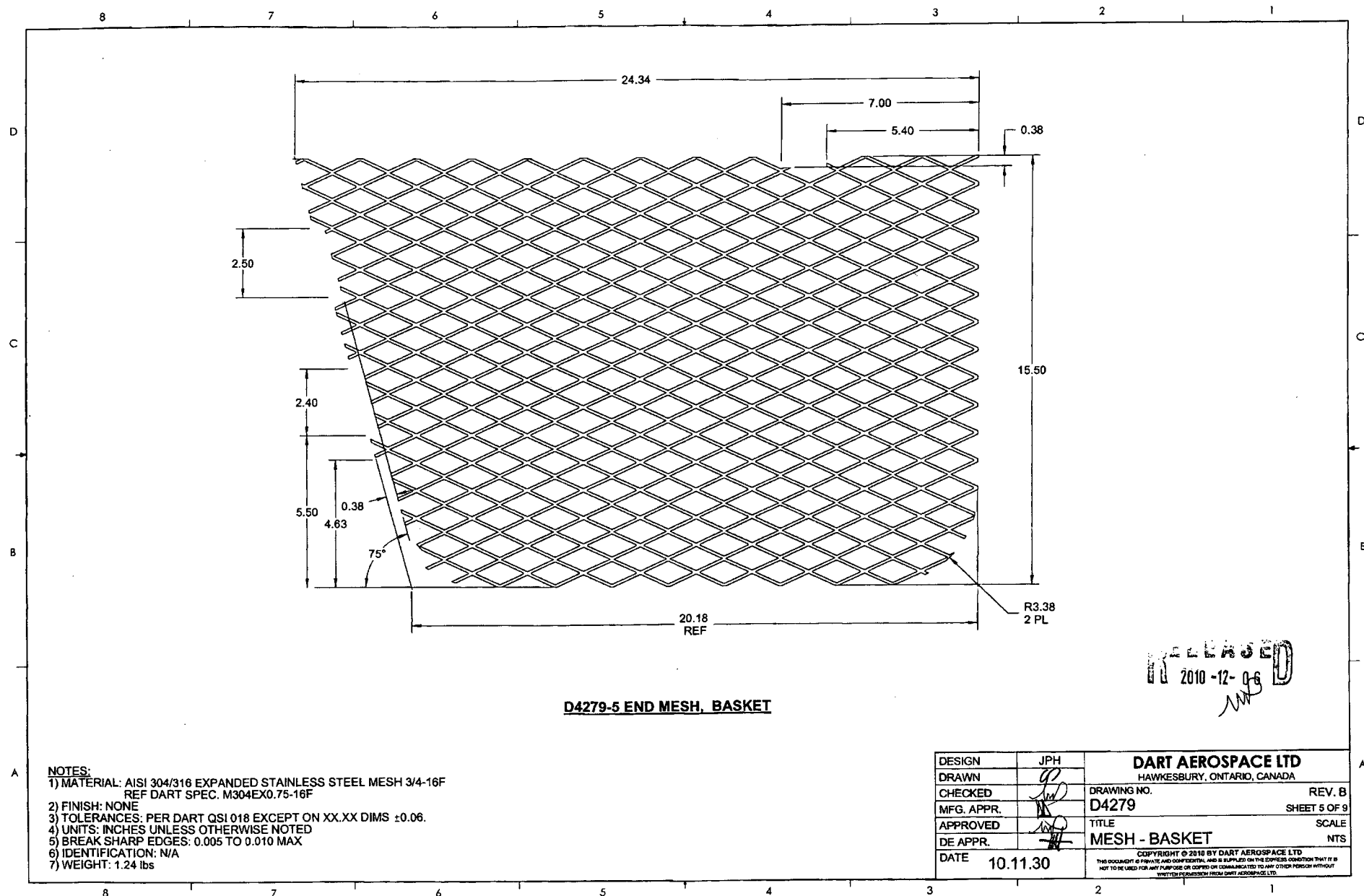
D4279-3F MESH-CHAMFER
(LOCAL SECTION MESH SHOWN FOR CLARITY)

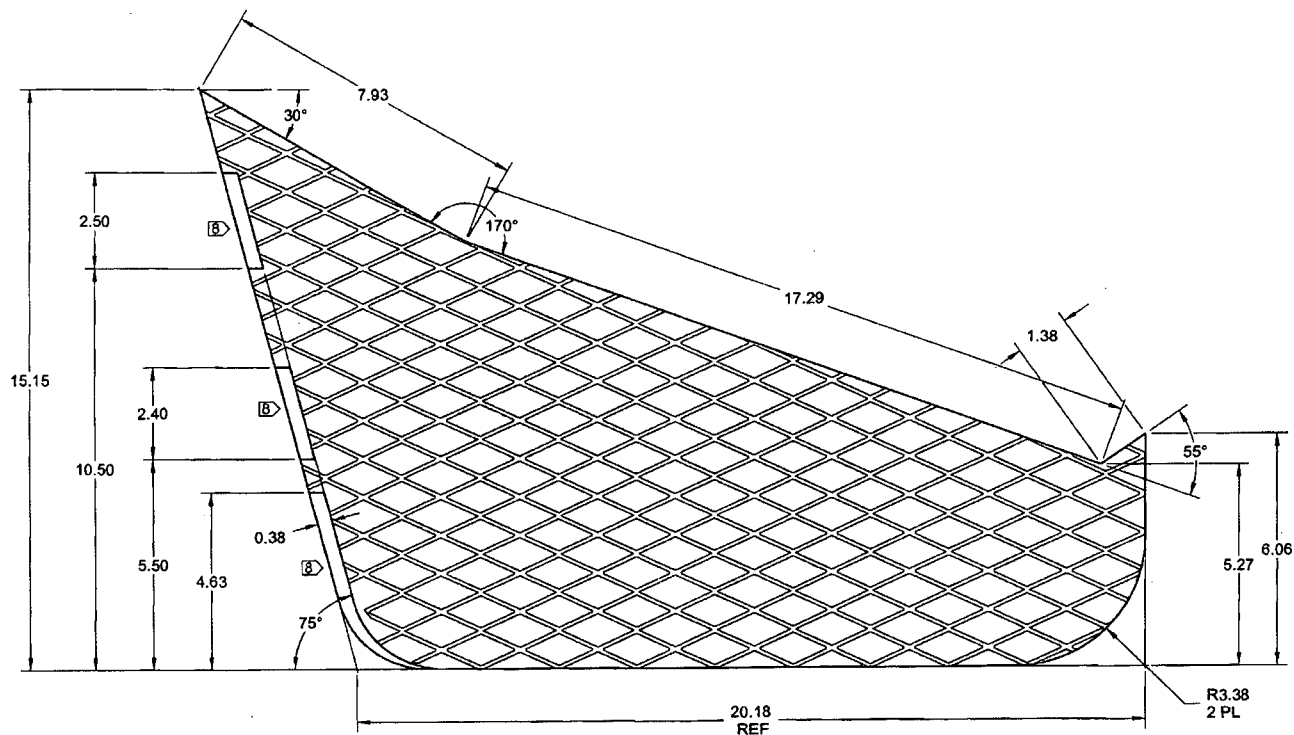
RELEASED
2010-12-06
M

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4279	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





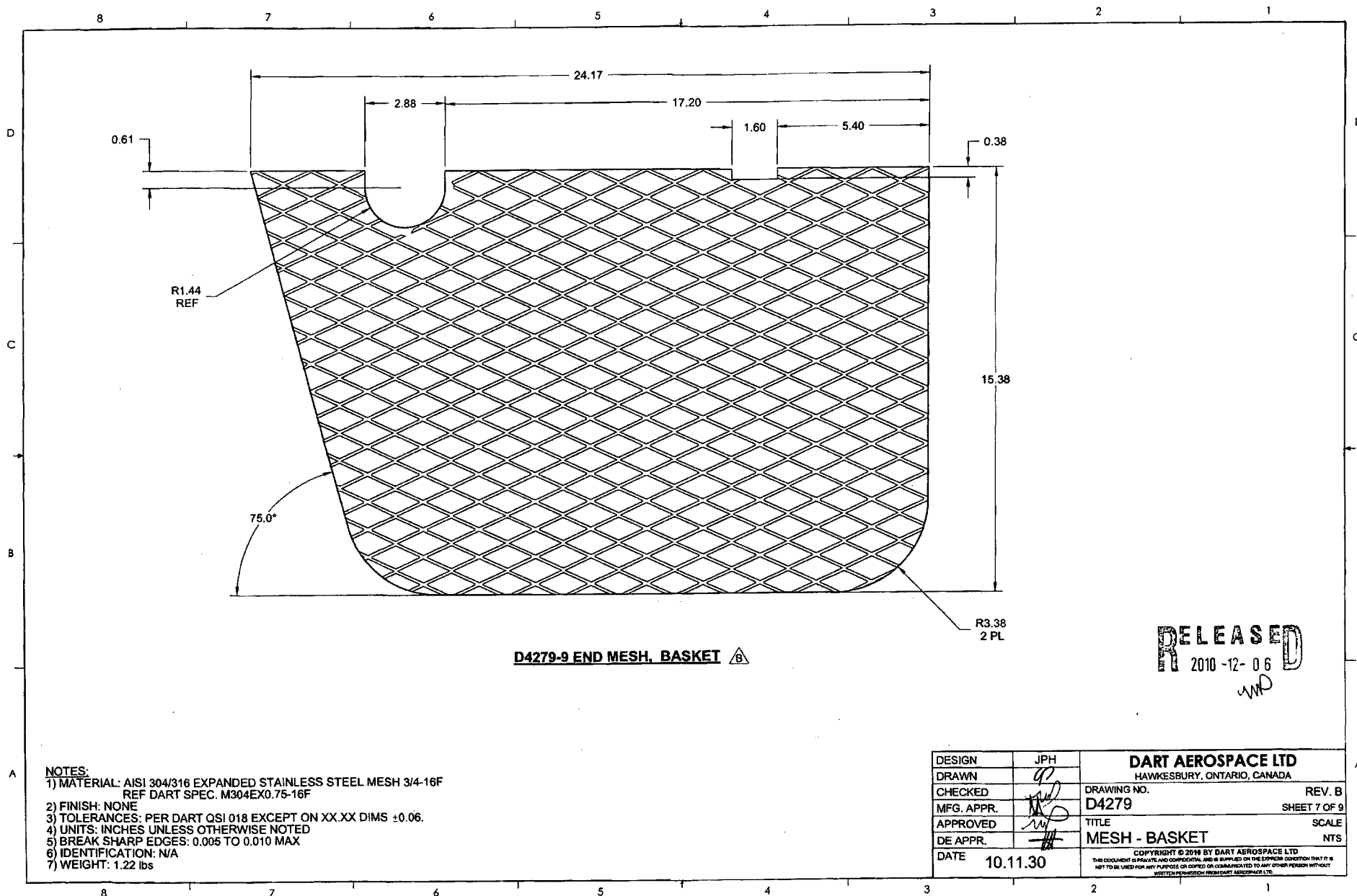
D4279-7 END MESH. BASKET

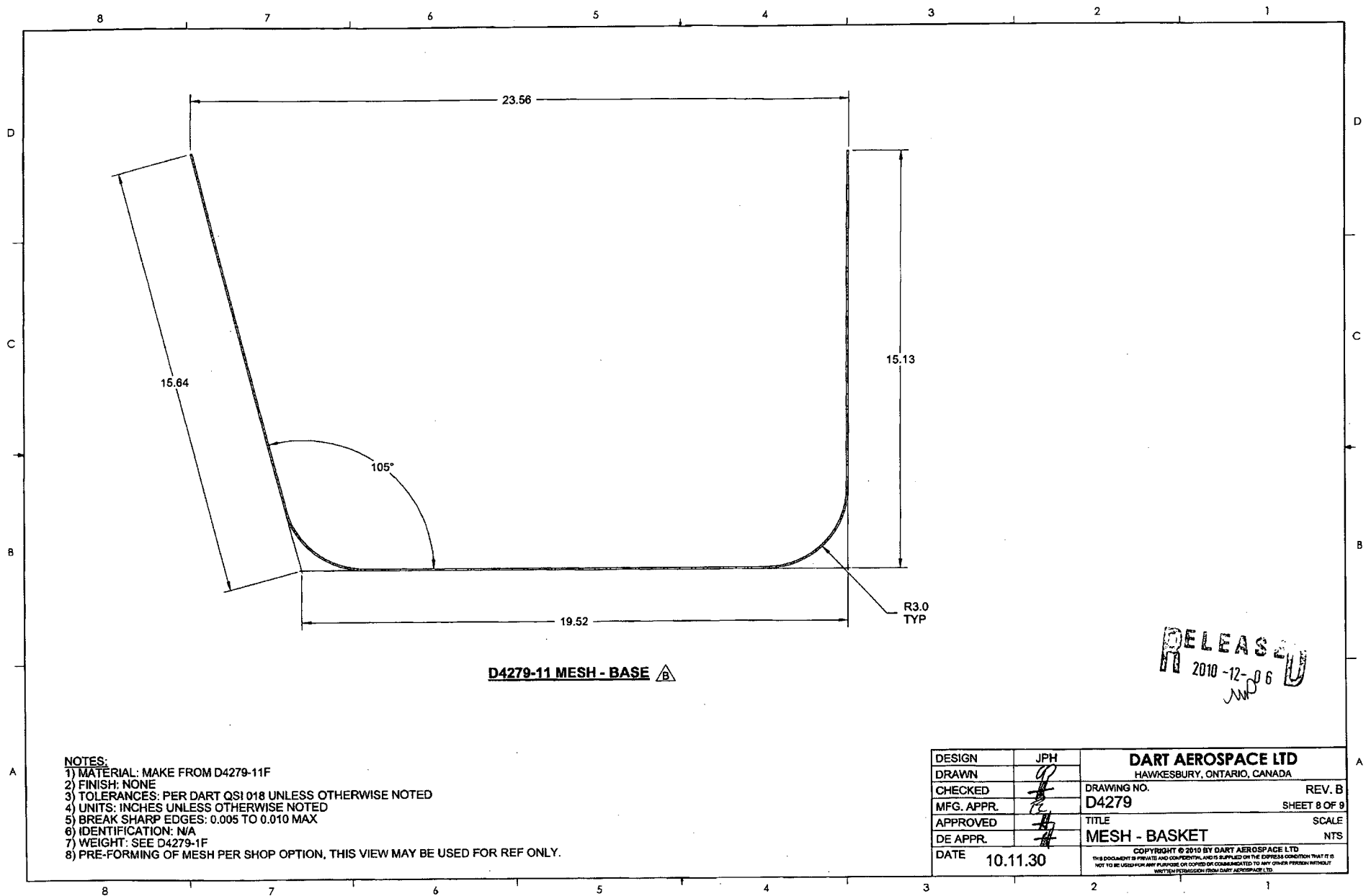
RELEASED
2010-12-86
JW

NOTES:

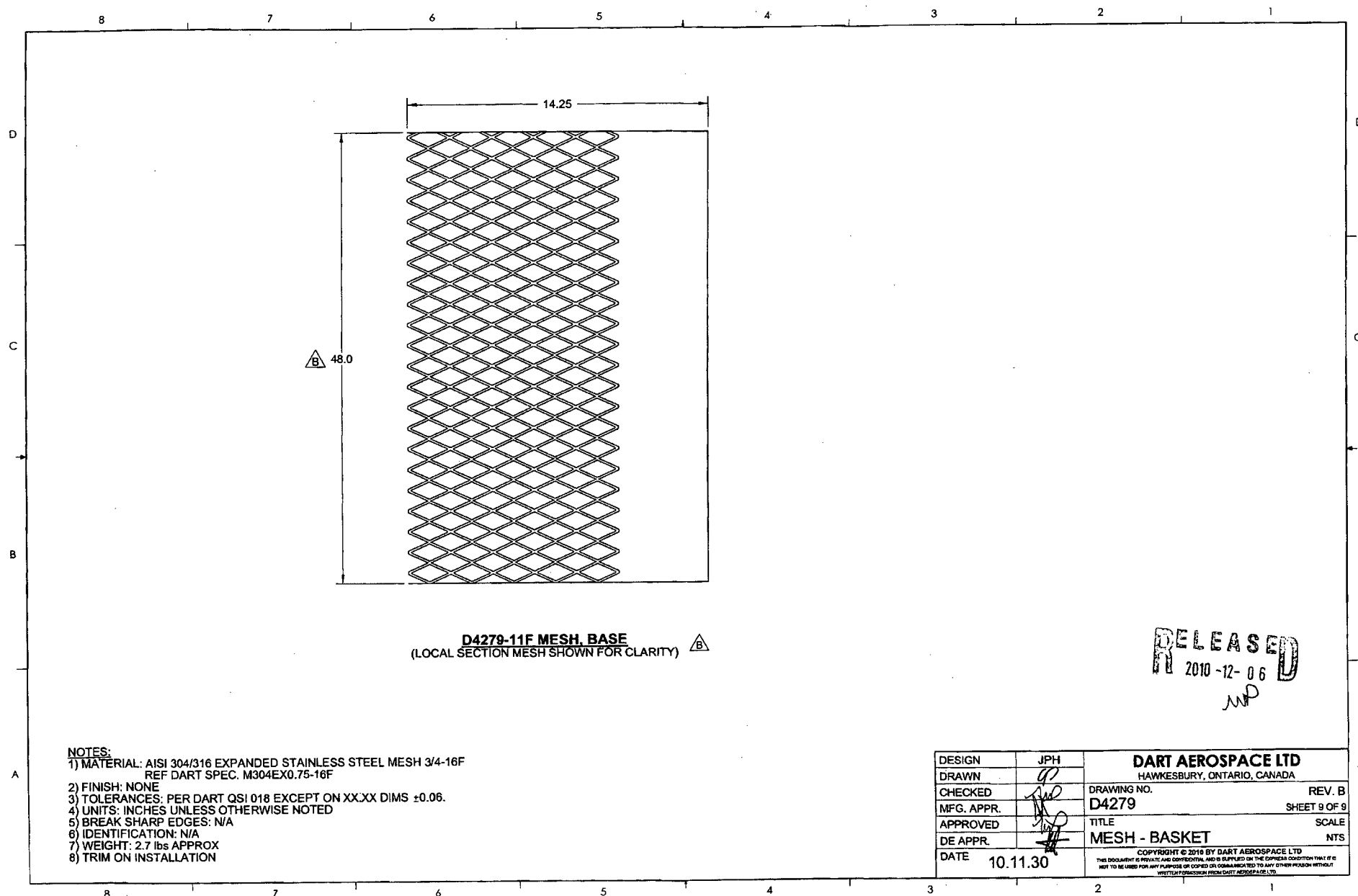
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs
- 8) TRIM ON INSTALLATION TO CLEAR HOLES (IF PRESENT)

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4279	REV. B
MFG. APPR.		SHEET 6 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		MESH - BASKET	NTS
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RELEASED
 2010-12-06
[Signature]



D4279-11F MESH, BASE
(LOCAL SECTION MESH SHOWN FOR CLARITY) B

RELEASED
2010-12-06
MD

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.7 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	MD	D4279	SHEET 9 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	MESH - BASKET	NTS
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